

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024488**Date Inspected:** 07-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** An Qing Xiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector, Anand Upadhye was present during the times noted above for observations relative to the work being performed.

**WELDING**

This QA Inspector observed the following work in progress:

**Outside Yard – OBG Trial Assembly**

This QA Inspector observed ZPMC qualified welding personnel identified as 069118 perform repair welding by Shielded Metal Arc Welding (SMAW), on Edge beam to Floor beam weld at panel point 126.5 of OBG Segment 14W. Weld joint is identified as SEG3020P-208. ZPMC Quality Control (QC) Inspector identified as An Qing Xiang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-1G-FCM-Repair-1, which is used as per Welding repair report B-WR20970. See attached picture.

This QA Inspector observed ZPMC qualified welding personnel identified as 067765 perform repair welding by Shielded Metal Arc Welding (SMAW), on Edge beam to Floor beam weld at panel point 126 of OBG Segment 14W. Weld joint is identified as SEG3020R-173. ZPMC Quality Control (QC) Inspector identified as An Qing Xiang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-1G-FCM-Repair-1, which is used as per Welding repair report B-WR20970.

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

This QA Inspector observed ZPMC qualified welding personnel identified as 069118 perform welding by Shielded Metal Arc Welding (SMAW), on Edge plate I Rib stiffener to Floor beam weld at panel point 126.5 of OBG Segment 14W. Weld joint is identified as SEG3020P-173. ZPMC Quality Control (QC) Inspector identified as An Qing Xiang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2112-FCM-1.

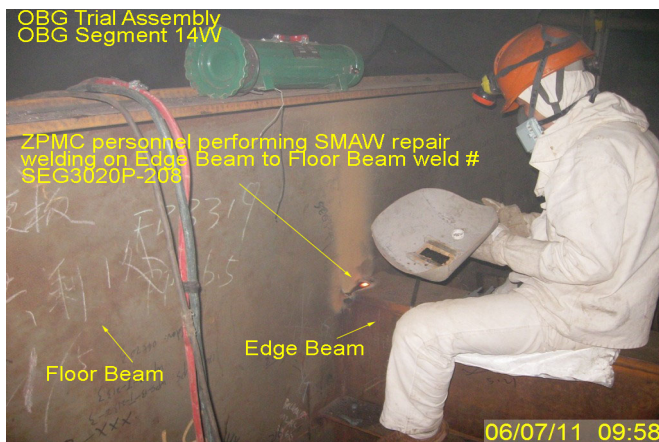
This QA Inspector observed ZPMC qualified welding personnel identified as 066751 perform welding by Shielded Metal Arc Welding (SMAW), on Side plate I Rib stiffener to Floor beam weld at panel point 126 of OBG Segment 14W. Weld joint is identified as SEG3020R-145. ZPMC Quality Control (QC) Inspector identified as An Qing Xiang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2214-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 066326 perform repair welding by Shielded Metal Arc Welding (SMAW), on Edge plate to Deck plate weld between panel points 125.5 and 126.5 of OBG Segment 14W. Weld joint is identified as SEG3020-021. ZPMC Quality Control (QC) Inspector identified as An Qing Xiang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1, which is used as per Welding repair report B-WR21150.

This QA Inspector observed ZPMC qualified NDT personnel perform Magnetic Particle Testing on Bottom plate I Rib stiffeners to Floor beam welds, Fit Lugs to Floor beam welds and Floor beam to Bottom plate welds at panel point 126.5 of OBG Segment 14W. See attached picture.

This QA Inspector observed ZPMC qualified NDT personnel perform Ultrasonic Testing on Deck panel diaphragm to Deck panel diaphragm welds at panel point 126.5 and 127 of OBG Segment 14W. Weld joint is identified as SEG3020P-006 and SEG3020M-008. One (1) Class A indication was marked by ZPMC NDT personnel on weld SEG3020P-006.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

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### Summary of Conversations:

No significant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, phone: 15000422372 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Upadhye, Anand	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford, William	QA Reviewer

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